

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019890**Date Inspected:** 27-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Yaxu.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component: Traveler Rails

PCMK: 20TR2-029

Weld No: 013

Welder: 203710

Repair No. B-WR19526

WPS-345-FCAW-1G(1F)-ESAB-Repair

Bay 6

This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates X4250L, X4251C and

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4650J for CB003M. (see photo below)

Bay 8

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in BK004A – 061, 062 and 064 at various locations due to contour grinding and visual indications as identified by ZPMC CWI Inspector Huang Min.

Bay 10

This Caltrans QA Inspector observed ZPMC installing internal ladder and splice plates on South Tower, Lift 5. ZPMC was observed reaming holes alignment, shimming and using a torque wrench for the bolts at this location. Which appeared to comply with approved practices as outlined in the contract documents.

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Yu Zhi Lai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A1-001

Weld No: 002

Welders: 052075, 053869, 040434, 050295

WPS-B-T-2231-B-226-5-2

Bay 11

This Caltrans QA Inspector observed ZPMC installing internal ladder and splice plates on East Tower, Lift 5. ZPMC was observed reaming holes alignment, shimming and using a torque wrench for the bolts at this location. Which appeared to comply with approved practices as outlined in the contract documents.

This Caltrans QA Inspector observed ZPMC using template to perform the match drilling process on Suspender Bracket ND1-BR5A5-2-6. (see photo below)

Bay 12

This QA Inspector observed the following work in progress for Bay 12.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Yu Zhi Lai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path (see photo below)

PCMK: guard rails

Weld No: frame to grating

Welders: 059373

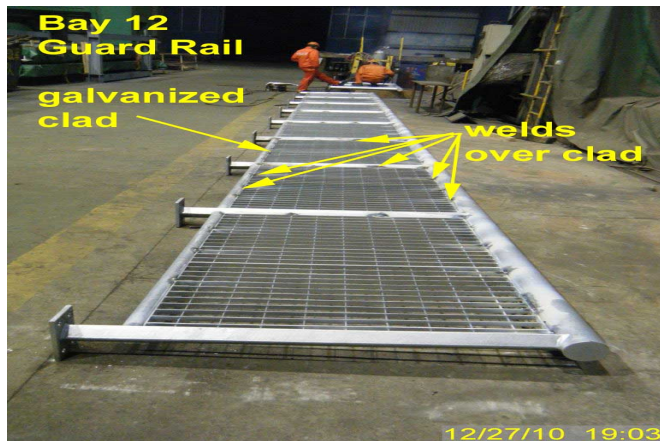
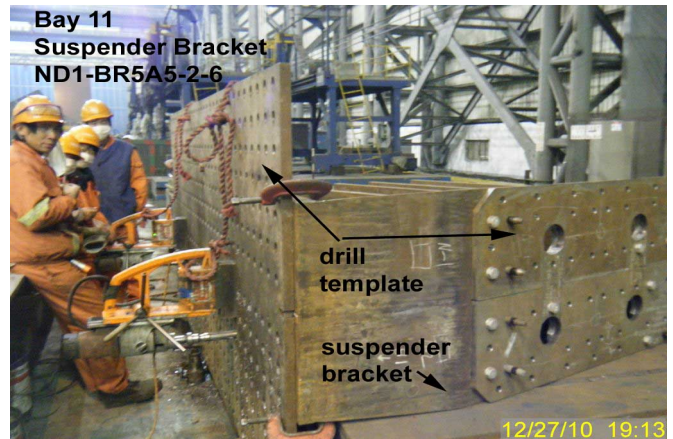
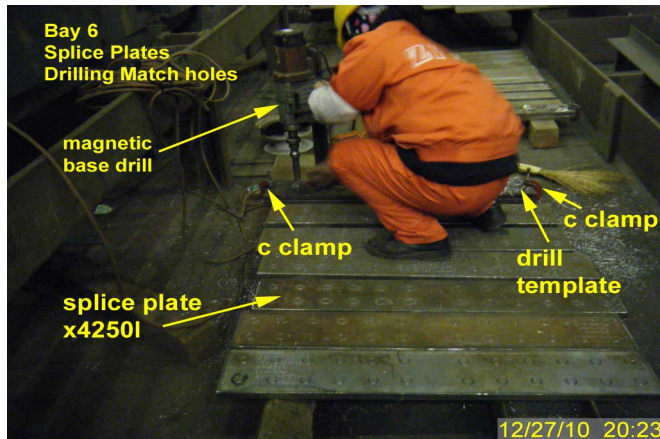
WPS-B-T-2231-ESAB

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This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds located in bike path guard rails at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
